

Work Order ID 80096

80096

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February-09-12 4:30:54 PM

Item ID: D2938-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle RH Out, 206
 Start Date: 09/02/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 23/02/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/02/10 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00
 100 HAAS 1 0.00
 HAAS CNC vertical machine #1

Memo

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110 CONVENTIONAL MILLING MACHINE 0.00
 110 Mill Conv 0.00
 Conventional Milling Machine

Memo

Machine Keyway and inspect per attached dimension sheet

120 QC1- Inspect dimensions to dimension sheet 0.00
 120 QC 0.00
 Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		BA 12/03/24		4	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4.	0	12300	
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 1h40 FINISH TIME: 320°F OVEN TEMPERATURE: m120222	0.00 0.00				4	0	0P 12/03/26	

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Item ID: D2938-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle RH Out, 206

Start Date: 09/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 428A	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

4 BL 12326

12/3/29 54 (4)

12/4/29

12-03-30

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Picklist Print

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Work Order ID: 80096

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Parent Item: D2938-2

D2938-2

Parent Item Name: Saddle RH Out, 206

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	57.0000	1	4			

D6101-003

Saddle Billet, 7075

**

Location	Loc Qty	Loc Code
MAT040	63	
73775	2	
73780	7	
78159	19	
78599	28	
MAT042	-7	
MAT044	1	
73769	1	

80765

4

F.K. 12/03/18.

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DART AEROSPACE LTD	Work Order:	80096
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.116	.116	.117		
B	0.100	0.140		.114	.116	.115	.116		
C	0.100	0.140		.117	.117	.117	.117		
D	0.210	0.230		.225	.225	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.260	.260	.260	.260		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.123	.123	.123	.123		
O	0.540	0.560		.550	.550	.549	.549		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.254	.254	.254	.254		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.261	1.261	1.261	1.261		
Y	1.565	1.585		1.576	1.576	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	KK / [Signature]
Date:	12/03/19

Audited by:	[Signature] B.A.
Date:	12/03/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

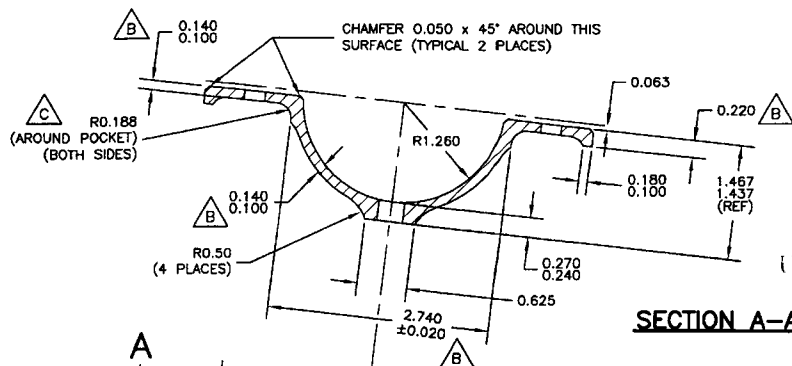
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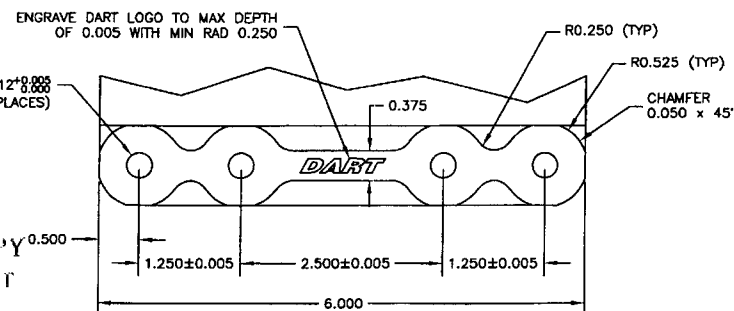
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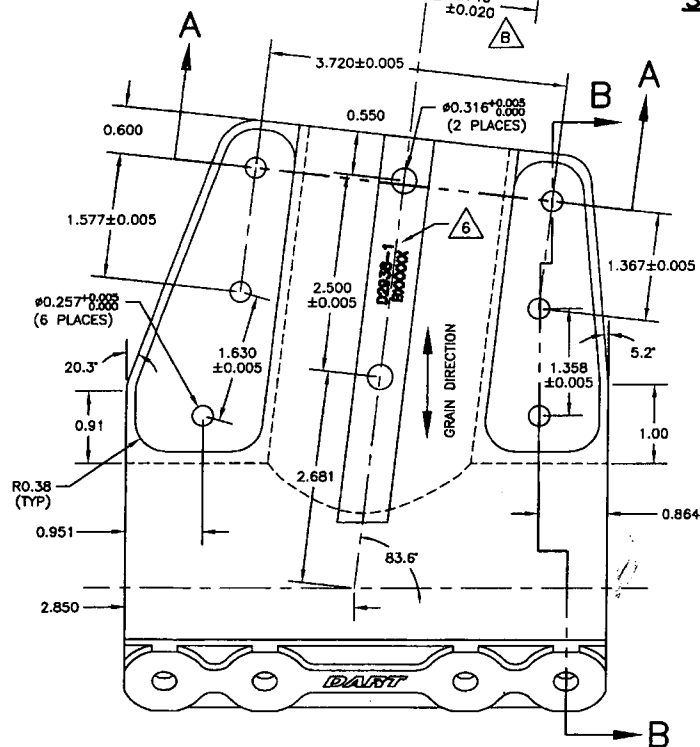


SECTION A-A

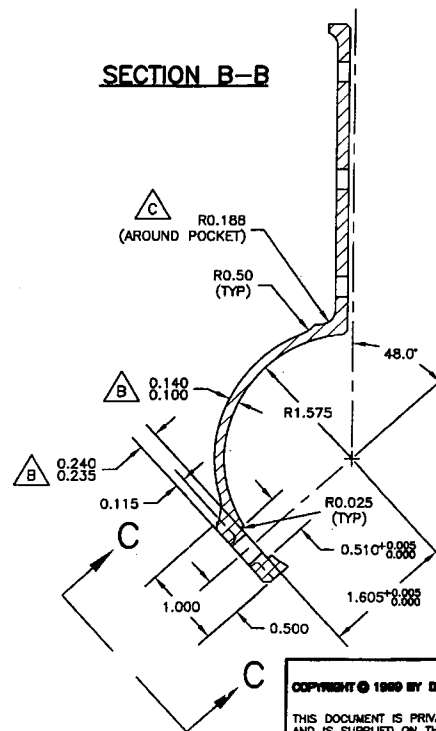
UNCONTROLLED COPY
RETURNED
TO
ORIGINAL
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 800.96 M.L.J
12/02/10



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	PH	DRAWING NO. D2938
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07.02.12

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